

Blue

Work Order ID 71080

Wednesday, June 22, 2011 8:48:26 AM

Page 1

Item ID: D2724-041

Accept

Setup Start

Revision ID:

Stop

Item Name: 206L Step Assembly

Start Date: 6/22/2011 Start Qty: 2.00

Cust Item ID:

Required Date: 7/8/2011 Req'd Qty: 2.00

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

D2724

Rev C

100

0.00



Large Fab

Large Fab

Memo

0.00

Large Fab

Cut D2724-1 using D2622 extrusion as per Dwg D2724
Deburr and bevel ends for welding

H/Ae

11.07.06

x2

Ø

110

0.00



Large Fab

Large Fab

Memo

0.00

Large Fab

Weld end cap and lugs as per Dwg D2724 using Jig DT8884 followed by
Jig
DT (One End Only)
A/R AL ROD Batch: m114703
Grind end cap welds flush m114884

H/Ae 11.07.06

2

Ø

Ae

11.07.15

2 Ø

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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120 QC9- Inspect visual per QSI004- Fusion Welds 0.00



QC Memo 0.00

Quality Control

2 0 BEN/07/15

130 QC5- Inspect part completeness to step on W/O 0.00



QC Memo 0.00

Quality Control

Sum 7/15

+2
44

140 Chemical Conversion Coat per QSI005 4.1 0.00



HandFinish Memo 0.00

Hand Finishing

11.07.15 Ae/14

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Item ID:	D2724-041	Accept		Setup	Start	
Revision ID:					Stop	
Item Name:	206L Step Assembly					
Start Date:	6/22/2011	Start Qty:	2.00		Cust Item ID:	
Required Date:	7/8/2011	Req'd Qty:	2.00		Customer:	
Reference:						

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150  QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.00		SB	11/07/18	②	φ		
160  Large Fab Large Fab	Large Fab Memo Inspect for foreign object per QSI 024 Weld Remainig end cap as per Dwg D2724 using Jig DT8884 followed by Jig DT A/R AL ROD Batch: 114703 Grind per dwg D2724	0.00 0.00				2	φ		11-07-18
170  QC Quality Control	QC!0- Inspect visual per QSI004- ground welds Memo	0.00 0.00		S	11/07/19	2	φ		

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____


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Revision ID: Stop 
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Start Date: 6/22/2011 Start Qty: 2.00  Cust Item ID:
Required Date: 7/8/2011 Req'd Qty: 2.00  Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start 
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop 

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

180  QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00		5 u/a 19		72 41			
---	---	--------------	--	----------	--	----------	--	--	--

190  HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1 Memo	0.00 0.00							
---	---	--------------	--	--	--	--	--	--	--

200  Powdercoat Powder Coating	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum Memo	0.00 0.00							
--	--	--------------	--	--	--	--	--	--	--

START TIME: _____
OVEN TEMPERATURE: _____
FINISH TIME: _____

Prime B117319
Delft Blue B118395
clear Delft B118053

21H 6 u/a 107/20

8T 11-07-26 (2)

W/O:		WORK ORDER CHANGES					
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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

210

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

M 11 07 27 (2)

220

Wing Walk as per dwg QSI005 4.4 Batch 1117867

0.00



HandFinish

Memo

0.00

Hand Finishing

2 0 11/07/22

230

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

11/07/22 (2)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Cust Item ID:

Required Date: 7/8/2011 Req'd Qty: 2.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

240

Identify as per dwg & Stock Location: _____

0.00



Packaging

Memo

PPD 71054

0.00

Packaging

250

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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NOTE: Date & initial all entries

Picklist Print

Wednesday, June 22, 2011 8:48:22 AM

Page 1

Work Order ID: 71080

Parent Item: D2724-041

Parent Item Name: 206L Step Assembly

Start Date: 6/22/2011

Required Date: 7/8/2011

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP Rev:E As Per Ecn 766 06-01-06 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D2622-120C

Manufactured

No

100

Each

145.7000

1



Step Extrusion

Location

Loc Qty

Loc Code

HALL

132

64409

6

68293

126

WA

13.7

46910

2

66970

11.7



2
11.07.06

WA 68293 (x2)

D2734

Manufactured

No

110

Each

83.0000

1



Step End Plate

Location

Loc Qty

Loc Code

WA

83

69537

8

70701

75



2
11.07.06

D2734

Manufactured

No

160

Each

83.0000

1



Step End Plate

Location

Loc Qty

Loc Code

WA

83

69537

8

70701

75



2
11.07.18

2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Picklist Print

Wednesday, June 22, 2011 8:48:22 AM

Page 2

Work Order ID: 71080

Parent Item: D2724-041

Parent Item Name: 206L Step Assembly

Start Date: 6/22/2011

Required Date: 7/8/2011

Start Qty: 2.00

Required Qty: 2.00

D3458-1

Manufactured No

110 Each

17.0000

2 4



Step Mounting Plate



11.07.06

Location

Loc Qty

Loc Code

WA018

17

63075

17

4

D3458-3

Manufactured No

110 Each

24.0000

2 4



Step Mounting Plate



11.07.06

Location

Loc Qty

Loc Code

WA018

24

63076

24

4

Wednesday, June 22, 2011 8:48:23 AM

Shop Packet Print

Page 2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

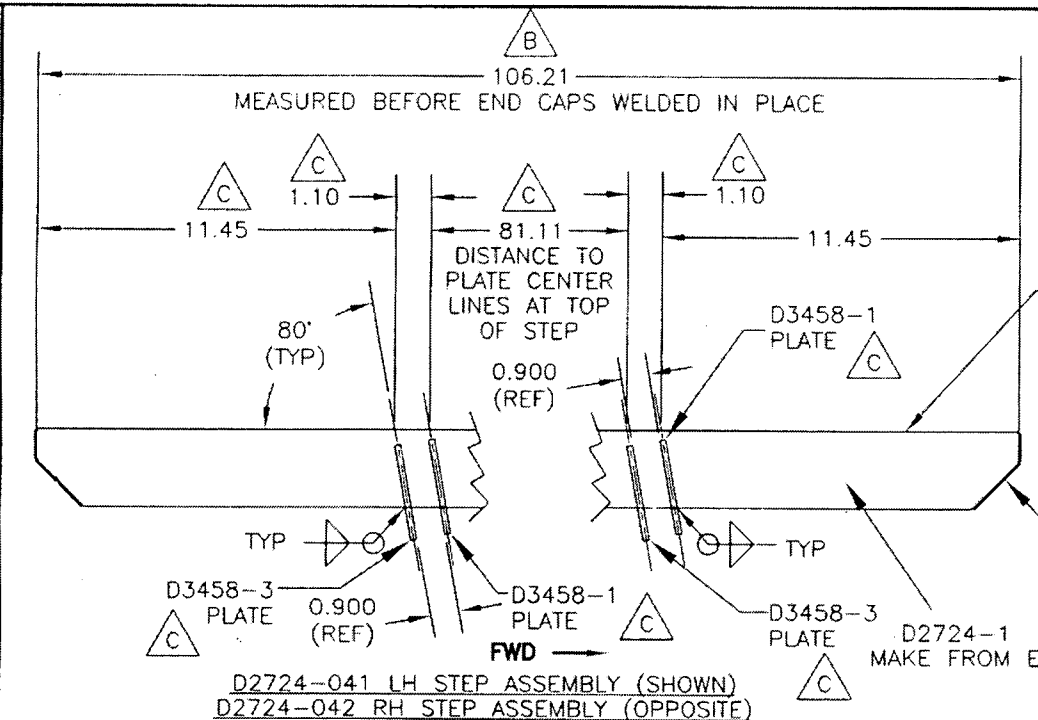
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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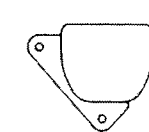
DART

RELEASED
05/11/14



NOTE: ALL WELDS SHALL BE 100% VISUALLY INSPECTED BY A QUALIFIED INSPECTOR PER DART QSI 004

APPLY BLACK ANTI-SKID ON TOP SURFACE TO BOTTOM OF TOP RADIUS

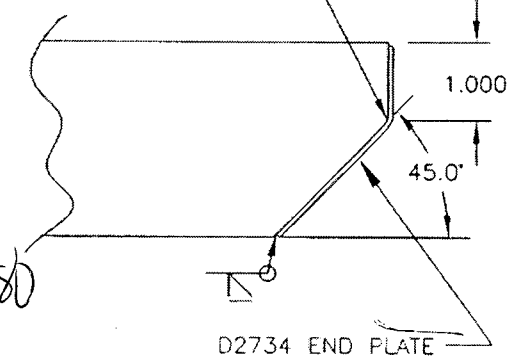


REFER TO STEP END DETAIL

D2724-1 MAKE FROM EXTRUSION D2622-107

D2724-041 LH STEP ASSEMBLY (SHOWN)
D2724-042 RH STEP ASSEMBLY (OPPOSITE)

ROUND CORNER OF EXTRUSION TO MATCH BEND RADIUS OF END PLATE



TYPICAL STEP END DETAIL
NOT TO SCALE

D2721-041/-042 STEP ASSEMBLY PARTS LIST

QTY - 041	QTY - 042	PART NUMBER	DESCRIPTION
X	X	D2724-041	LH STEP ASSEMBLY
		D2724-042	RH STEP ASSEMBLY
1	1	D2622-107	EXTRUSION
2	2	D2734	END PLATE
2	2	D3458-1	PLATE
2	2	D3458-3	PLATE

D2724-041/-042 STEP ASSEMBLY

- 1) MAKE FROM EXTRUSION D2622
- 2) WELD PER DART QSI 004
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3
APPLY BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) ALL TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

DESIGN	KE	DRAWN BY	PH	DART AEROSPACE USA, INC.
CHECKED		APPROVED		PORT HADLOCK, WA
DATE	05.09.19			
	A	97.12.04	NEW ISSUE	
	B	98.10.19	UPDATED WELD DETAIL REVISED TOLERANCES	
	C	05.09.19	RE-DESIGN, ADD D3458-1/-3	
			206L/407 STEP ASSEMBLY	
			SCALE	
			NTS	
				REV. C
				SHEET 1 OF 1

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